

Work Order ID 163747-1
Thursday, July 06, 2017 1:05:19 PM

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Item ID: D4703-045 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Lock Pin Assembly
Start Date: 7/10/2017 Start Qty: ~~10.00~~ *10*
Required Date: 7/13/2017 Req'd Qty: 10.00 *10*
Reference: Cust Item ID:
Customer:

Approvals: Process Plan: [Signature] Date: JUL 06 2017 Tooling: Date: Run Start *NR1*
QC: [Signature] Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4703	B

100	Cut blanks as per folio	0.00							
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100
Bandsaw
Jeaspa Bandsaw
Memo
CUT BLANK AT 4.000"
N/A [Signature] JUL 06 2017

110		0.54							
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110
HAAS 1
HAAS CNC vertical machine #1
Memo
1- MACHINE AS PER DWG D4703-3 & FOLIO FB519
FOLIO REV: _____
DWG REV: _____
N/A [Signature] JUL 06 2017

2- Deburr and break all sharp edges

3- Finish tapping manually as per folio, length of helicoil insert is 3/8".

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.10	N/A	(H)	JUL 06 2017				
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.20	N/A	(H)	JUL 06 2017				
132 *132* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O to ATG : _____ 1- Anodize as per Dwg. D4703-3 (see note 2) Certification of Conformity is required	0.00 720.00	N/A	(H)	JUL 06 2017				

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
134 *134* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.20	N/A (N/A)		JUL 06 2017				
135 *135* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	N/A (N/A)		JUL 06 2017				
136 *136* Small Fab Small Fab	ASSEMBLE AS PER DWG. D4703-045 1- INSTALL HELICOIL 2- INSTALL D4705-1 QUICK RELEASE PIN WITH LOCTITE AS PER DWG.	0.00 1.66				1	Ø	JUL 10 2017	DAS 19 9-00

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Required Date: 7/13/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
138 *138* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.20				1			DAS 38 9-89 JUL 11 2017
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>5+119</u> Memo	0.00 0.10				1			JUL 11 2017 DAS 6 9-89
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.00							17/7/13 J

u17.07.12

Picklist Print

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Work Order ID: 163747

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Parent Item: D4703-045

D4703-045

Parent Item Name: Lock Pin Assembly

Start Date: 7/10/2017

Required Date: 7/13/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV: A NEW ISSUE JFS 17/01/11 VERIFIED BY: DD IPP REV:
B AS PER DWG. REV.B JFS 17/06/19 VERIFIED BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4703-3		Manufactured	No		162270		Each	0.0000		10			
D4703-3									** ①			JUL 10 2017	DAS 19 9-89
Lock Pin Base													
M6061T6B1.000X02.50		Purchased	No			100	f	15.3130	0.334	3.515789			
M6061T6B1.000X02.500									**				
6061-T6 Bar 1.00 x 2.50													
					Location			Loc Qty		Loc Code			
					MAT003			15.313					
					M128437			0.4					
					M137365			14.913					
D4705-1		Manufactured	No			136	Each	0.0000	2	20			
D4705-1									** ②			JUL 10 2017	DAS 19 9-89
Pin, Quick Release													
MS21209-F415		Purchased	No			136	Each	53.0000	2	20			
MS21209-F415									**				
Heli-Coil												JUL 10 2017	DAS 19 9-89
					Location			Loc Qty		Loc Code			
					ST296			53		①			
					M133640			2					
					M136643			1					
					M137951			50		①			